



Date: Tuesday, 8/7/2007 7:33:39 AM
User: Jean-Luc Menard



Process Sheet



Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : "T" HANDLE ASSEMBLY
Job Number : 33831	
Estimate Number : 11179	
P.O. Number : <i>N/A</i>	Part Number : D2282041
This Issue : 8/7/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2282 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 8/7/2007 Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 33390A	Material : <i>N/A</i>
Written By : <i>JL 07-08-07</i>	Due Date : 8/14/2007 Qty: 50 Um: Each
Checked & Approved By : _____	
Comment : Est Rev: A Removed from 9 Digit 05-12-02 JLM	



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :								
1.0	D22823	Tube								
										
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2282-3</td> <td>Handle tube</td> <td><i>B33829</i></td> </tr> </table> <p style="text-align: right;"><i>JL 07/08/07 (50)</i></p>			Qty	Part Number	Description	Batch	1	D2282-3	Handle tube	<i>B33829</i>
Qty	Part Number	Description	Batch							
1	D2282-3	Handle tube	<i>B33829</i>							

2.0	D22825	Tube								
										
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)</p> <p>Pick:</p> <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2282-5</td> <td>Handle tube</td> <td><i>B33416</i></td> </tr> </table> <p style="text-align: right;"><i>JL 07/08/07 (50)</i></p>			Qty	Part Number	Description	Batch	1	D2282-5	Handle tube	<i>B33416</i>
Qty	Part Number	Description	Batch							
1	D2282-5	Handle tube	<i>B33416</i>							

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration.</p> <p>A/R ER316L SS Filling Rod <i>M18712</i> Dwg Rev: <i>E</i></p> <p style="text-align: right;"><i>JL 07-08-07 (50)</i></p>		

4.0	DO NOT USE <i>Q29</i>	WELD INSPECTION
		
<p>Comment: WELD INSPECTION</p> <p style="text-align: right;"><i>JL 07/08/07 (50)</i></p>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 33831

Part Number: D2282041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SA 07.08.05 (50)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.08.08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/08 (52)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/09

Job Completion

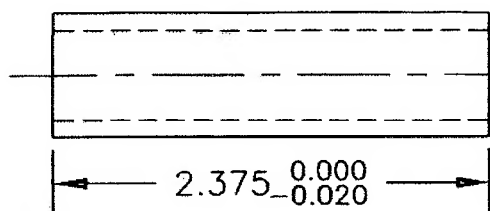


07/08/09

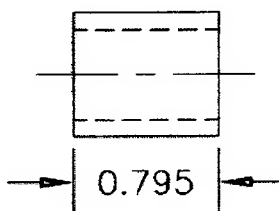


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

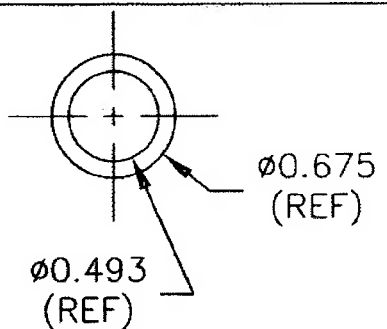
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[Signature]
05/09/16



D2282-3

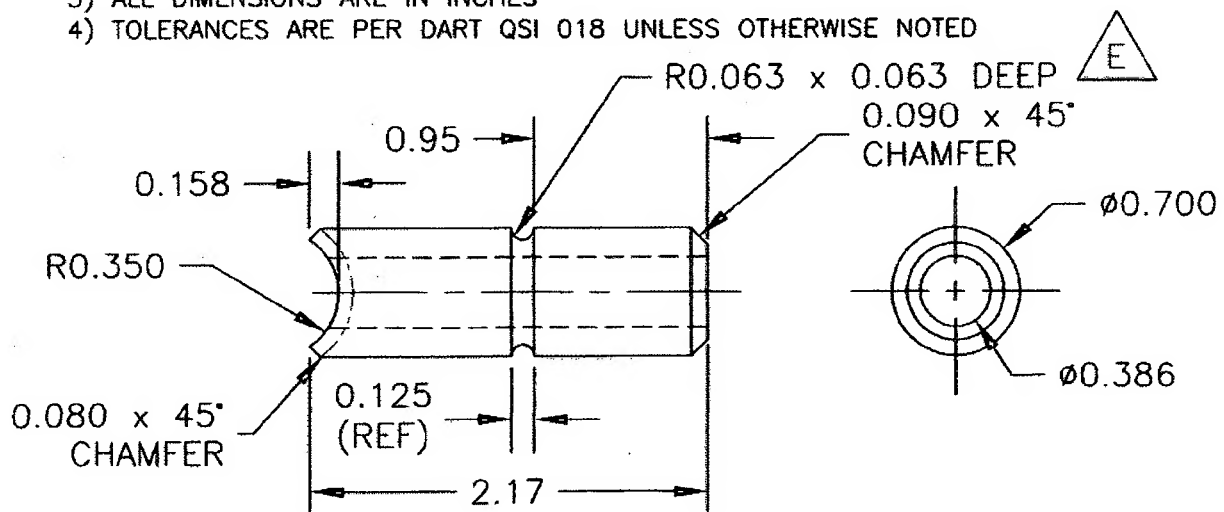


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

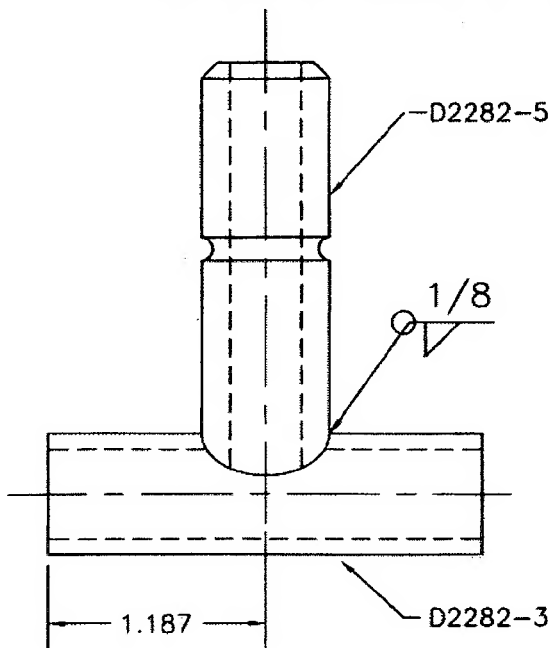


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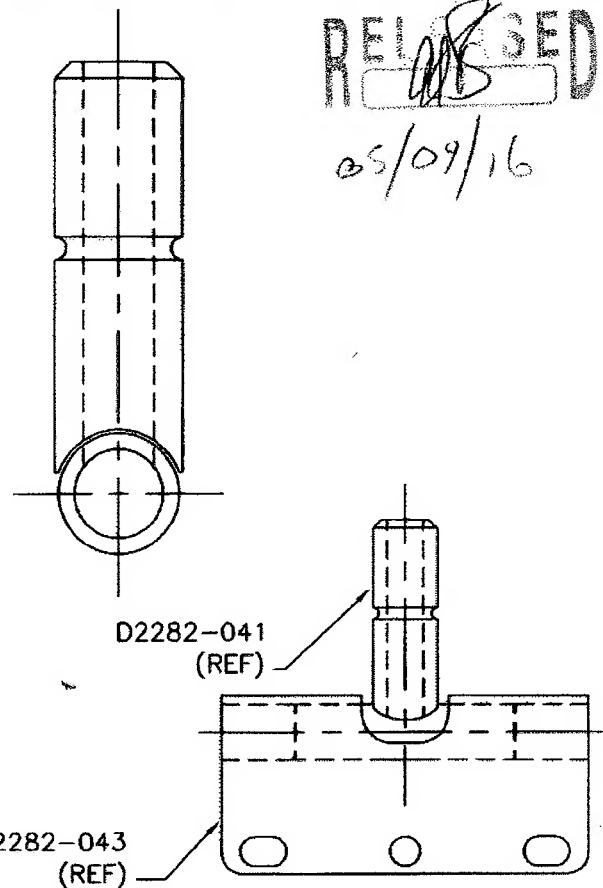
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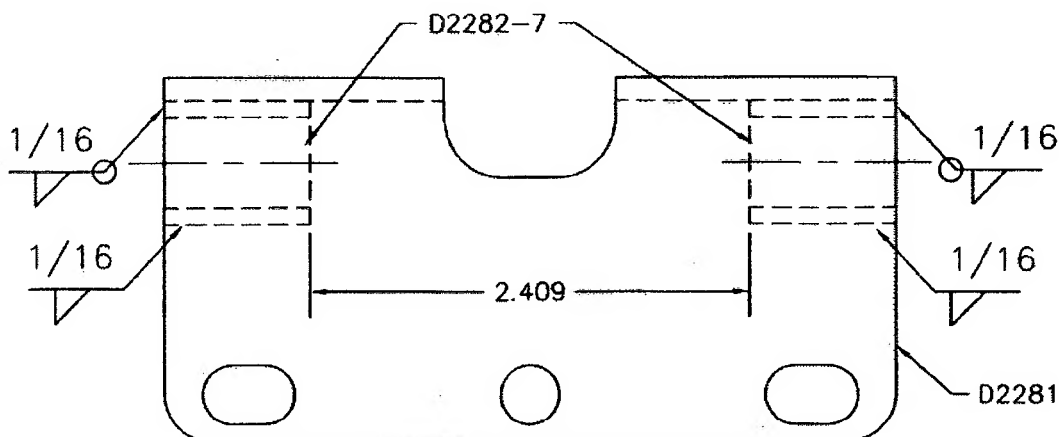
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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